

Date: Monday, 07/04/2008 11:47:18 AM
 User: Julie Lecocq

Process Sheet

0205-564-041

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 38432		
Estimate Number	: 12403		
P.O. Number	:	Part Number	: D3511041
This Issue	: 07/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3511 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 38267	Drawing Revision	: A
	Type	Material	:
	: SMALL /MED FAB	Due Date	: 30/04/2008
Written By	:	Qty:	6 Um: Each
Checked & Approved By	: <u>JD 08.4.06</u>		
Comment	: Est Rev:A New Issue 06-05-04 JLM		
	: Est.Rev:B New process 06-05-05 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET .188" THICK
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Comment: Qty.: 1.5572 sf(s)/Unit Total : 9.3429 sf(s)
 304 SHEET .188" THICK
 (M304S0188)
 Batch: 107676 IB 8-4-10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3511
 Dwg Rev: A
 Prog Rev: A

IB 8-4-10

2-Deburr if necessary

Identify as D3511-1

IB 8-4-10

⑦

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEIB 8-4-10

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5 08/04/10 (+7)

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Seq. #: Machine Or Operation: Description :

5.0 D35031 CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)
CUP

Batch: *335670=2 328277=4 338283=50 08.04.11 7*

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

SB 08/04/11

(7)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/11 (7)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld as per Dwg D3511

A/R SS ROD Batch: *M106162*

08.04.16

(7)

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Form as per Dwg D3511

SB 08/04/16 (7)

10.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-16 (7)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.04.16 (7)

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 100700

08-04-2

30 min.
23/04/2008
S.095 11.08
#1 319.0 F
#3 351.0 F
#3 38432 F

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Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



70

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/09/23

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 238A

PC 8/9/23 7

15.0

QC21

FINAL INSPECTION/W/O RELEASE



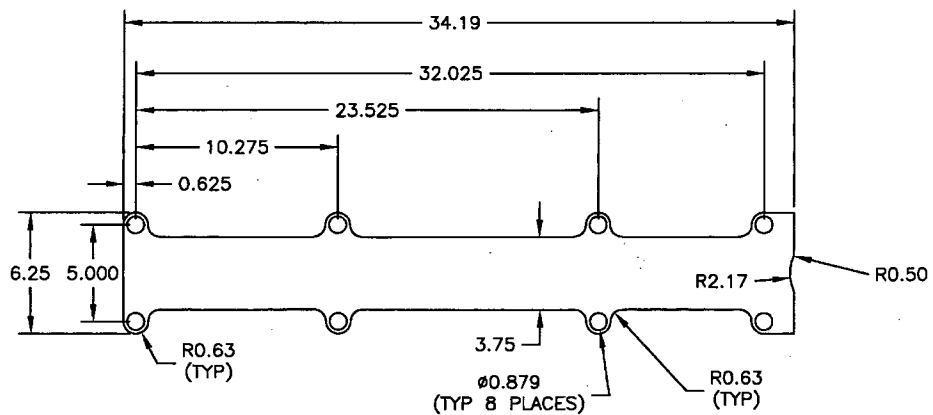
08/04/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

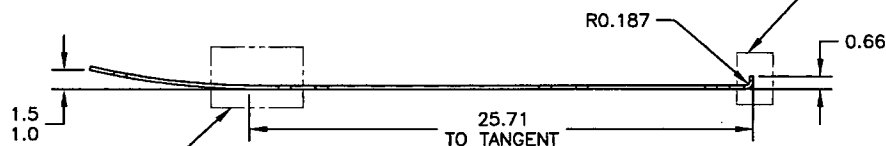


u 08.04.24



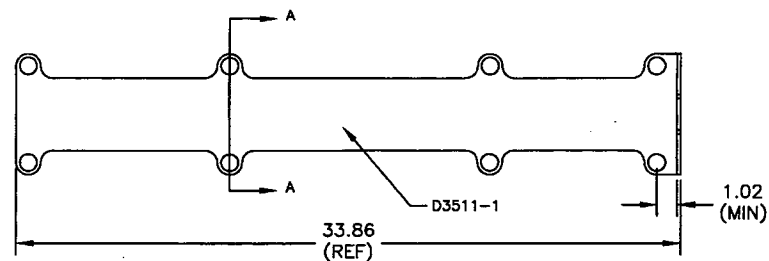
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



D3511-1 BEND DETAIL

NOTE: BEND AFTER WELDING



SECTION A-A

D3511-041 WELD DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35432

RELEASED

06 04 25

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A	06.04.04	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	J.H.	APPROVED
DATE	06.04.04	TITLE
		WEARPLATE
		SCALE
		NTS

DART

DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.
D3511

REV. A
SHEET 1 OF 1